



DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D2311	REV. D SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

D2311 HIGH LONG STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2311	High Long Step Assembly	X
D2244-118.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16



*cut per drawing

RELEASED
05.11.28 PH

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

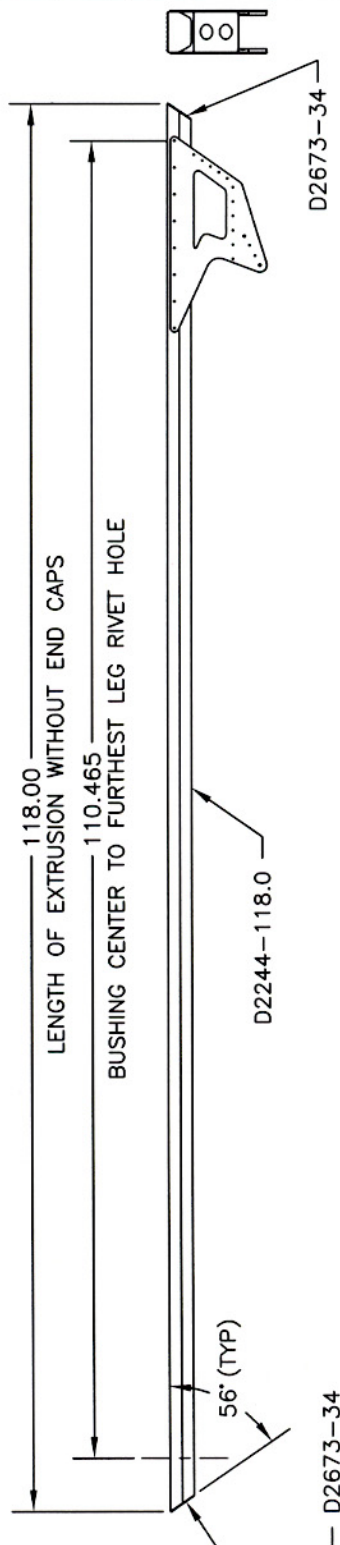
DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2311	REV. D SHEET 2 OF 2
DATE 05.11.14	TITLE HIGH LONG STEP ASSEMBLY		SCALE NTS

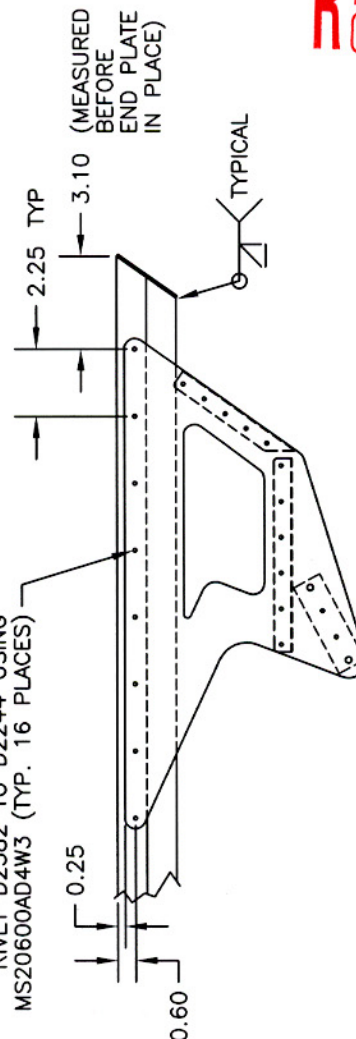
BLACK ANTI-SKID TOP SURFACE
TO BOTTOM OF TOP RADIUS

D2275
BUSHING
DRILL HOLE THROUGH EXTRUSION
TO FIT $\phi 1.25$ BUSHING
WELD BUSHING INTO HOLE WITH
COUNTER BORE FACING UP

FACE TOP OF STEP ON
CENTER WITH BUSHING
USING $\phi 1.875$ FACING TOOL
FACE TO REMOVE RIDGES
ON EXTRUSION



DRILL $\phi 0.128$ ON BOTH SIDES OF
D2244 TO MATCH D2582 HOLE PATTERN
RIVET D2582 TO D2244 USING
MS20600AD4W3 (TYP. 16 PLACES)



RELEASED
05.11.28

STEP LEG DETAIL

D2311 HIGH LONG STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.